



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

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RBE350A93-3232-00

Job Sheet 195073



Part No: RBE350A93-3232-00

Job Qty: ² pcs

Part Name: Seal & Seal Holder Replacement



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/13/19

Job Tracking No:

Due Date: 7/2/19

Created By: Marie Lajeunesse

Type: SOLD

Description: *order 11876*

Note: DWG RBE350A93-3232-00 Rev A IPP Rev. A 19.05.02 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	1 pcs	7/2/19		0.00	0.10	Small Fab - 1		
							Small Fab - 2		<i>MLL</i>
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	1 pcs	7/2/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
120	Packaging 3-1 - Stock - B4B	1 pcs	7/2/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		



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Container No: S197875



Part: RBE350A93-3232-00

Job No: 195073

Serial No/Batch: S197875

Revision: A

Inspector:

Exp Date:

Instructions:

Date: 07/15/19

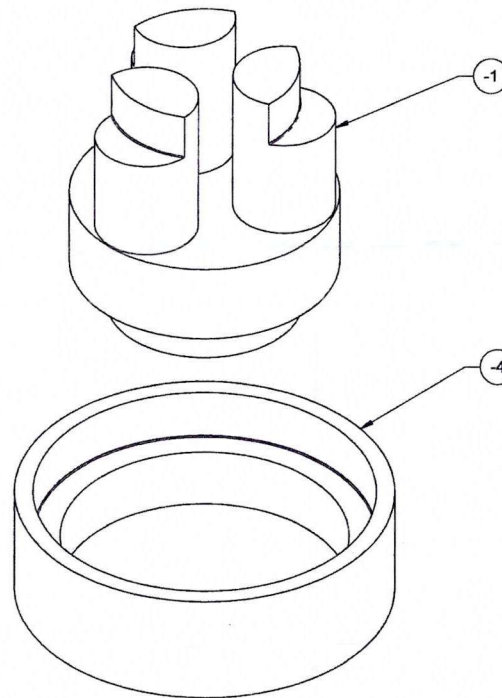
DAS
40
9-89

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					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	MLL
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
130	QC 21 - FG	1 pcs	7/2/19	0.00 0.00	QC 21 - FG - 21	
					QC 21 - FG - 70	JUL 15 2019
					QC 21 - SA - 53	
						DAS 70 9-89
Part Op 100 - 1-Pick bag and tag. 2-Ensure pieces do not hit/rub up against each other in the bag. Package accordingly. Descriptions:						
Job BOM						
Part / Item	Component Name	Quantity	Operation	Container		
RBE350A93-3232-00-1	Seal Holder Assembly	1 pcs (1 ea)	100-Small Fab - 1	5197230		
RBE350A93-3232-00-4	Seal Ring	1 pcs (1 ea)	100-Small Fab - 1	5189605		
Job Allocations						
Operation	Component Part	Required	Inventory	Allocated		
100-Small Fab - 1	RBE350A93-3232-00-1	1	0	0		
	RBE350A93-3232-00-4	1	0	0		
Part Specifications						
Specifications could not be found.						

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ITEM #	QTY	PART #	PART TITLE
-1	1	RBE350A93-3232-00-1	SEAL HOLDER ASSY
-4	1	RBE350A93-3232-00-4	SEAL RING



RBE350A93-3232-00 SEAL & SEAL HOLDER REPLACEMENT

NOTES:

1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH:

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) IDENTIFICATION: N/A

7) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 195073 MWS
19-05-14

SEE PREVIOUS PDF FOR OLDER REV TEMPLATE UPDATED PER DART HAWKESBURY STANDARDS ITEM -7 CHANGED FOR ITEM -4 ITEM -8 McMaster#98381A468 DELETED ITEM -3 CHANGED FOR ITEM -2 ITEM -5 CHANGED FOR ITEM -3 ITEM -1 FINISH BLACK OXIDE CHANGED FOR ZINC PLATE YELLOW, MANUFACTURING PROCESS CHANGED ITEM -2 DIMENSION 3X .5004/5000 CHANGED FOR 0.5000 +0 / -0.0008, DIMENSION 3X .1282/1285 REMOVED, DIMENSION 3X .313 REMOVED, DIMENSION R0.008" MAX ADDED, DIMENSION 1.260 CHANGED FOR 1.260 +0/-0.005", ENGRAVING S/N AND "MADE IN USA" REMOVED AND P/N RBE350A93-3232-10 REPLACED BY RBE350A93- 3232-00 ITEM -3 SLOT .1282/ 1285 REMOVED, DIMENSION .250 REMOVED, DIMENSION R0.008 MAX ADDED, DIMENSION .5008/5005 CHANGED FOR 0.5000 +0.0008/-0, CENTER DRILL NOTE ADDED, MATERIAL SP CHANGED FOR 1144 STRESSPROOF ITEM -4 MATERIAL SP CAD PLATE CHANGED FOR 1144 STRESSPROOF ZINC PLATE YELLOW, ENGRAVING RBE350A93-3232- 20 CHANGED FOR RBE350A93-3232-00, DIMENSION R0.008" ADDED		19-717	VM
REV.	DESCRIPTION	ECN #	BY
DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. A
MFG. APPR.	JFC	RBE350A93-3232-00	SHEET 1 OF 5
APPROVED	WJP	TITLE	SCALE
		SEAL & SEAL HOLDER REPLACEMENT	NTS
DATE	5/1/2019	COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐						
Date : _____		Sequence # : _____		QTY Affected : _____		MRB (QSI042) ☐		
Description Work Order Deviation				Disposition				
								Completed By
								Lead hand / Supervisor
								QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread						
Other/Details:								